Dart Aerospace Ltd.
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Rush

D2743

Job Sheet 187068

Part No: D2743 **Job Qty:** ~~60 ea~~ 100

Part Name: Crossbolt Spacer

Part Weight: 0 lbs **Status:** New **Priority:** Medium

Job Created: 11/27/18 **Job Tracking No:**

Due Date: 12/7/18 **Created By:** Jesse White

Type: SOLD **Description:**

Note: DWG REV B IPP E 05.04.13 Reformat; removed tumble and deburr step KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Standard Run Hrs	Workcenter/Supplier Workcenter / Supplier	Lead Time	Sign-off
90	**Start up Operation**	60 Ea		12/7/18	0.00	0.00	Start Up Machining-1	1W	JSD 14-12-07
100	**Hardinge**	60 pcs		12/7/18	0.01	1.28	Hardinge		" "
110	**QC**	60 pcs		12/7/18	0.00	0.00	QC2 Machining-1		" "
120	**QC**	60 pcs		12/7/18	0.00	0.00	QC8 Machining-1		KT 18-12-05
130	**Skidtubes**	60 pcs		12/7/18	0.00	0.47	Skidtubes-3		BE
160	**Packaging**	60 pcs		12/7/18	0.00	0.00	Packaging3-1		BE
170	**QC21-SA**	60 Ea		12/7/18	0.00	0.00	QC21		DEC 04 2018

Part Op Descriptions: **100** - 1-TURN AS PER FOLIO FA202 & DWG D2743
130 - 1- Clean crossbolt spacer with utra bright aluminum cleaner
160 - ***STOCK IN SKIDTUBE CELL***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6T0.625W.065	6061-T6 Round Tube .625 X.065W	16.0020 ft (.2667 ea)	90-Start up Operation	S108843

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6T0.625W.065	16	67	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Cross Bolt Spacer	3.085inches + 0.030 - 0.000	3.115 3.085		
2	Cross Bolt Spacer	0.625inches ± 0.010	0.635 0.615		
3	Cross Bolt Spacer	0.050inches ± 0.010	0.060 0.040		
4	Cross Bolt Spacer	45.000Degrees ± 0.000	45.000 45.000		
5	Cross Bolt Spacer	0.065inches ± 0.010	0.075 0.055		

Plex 11/27/18 11:30 AM dart.white.jesse

DQA: _____ Date: _____

QA Closed: Date:

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

Work Order update only ☐

Work Order: _____

Part No. _____

NCR No.

DISPOSITION

Rework	☐
Scrap	☐
Use-as-is	☐
Suspected Unapproved	☐

AGAINST DEPARTMENT/PROCESS

Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
Machining	☐	Small Fab	☐	Prod. Eng. Coor.	☐	Quality	☐
Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
Large Fab	☐	Composite	☐	Supplier	☐		

Date :

Step #:

Description Work Order

MRB (QSI042) Approval

Completed By

Lead hand / Supervisor Approval Verification

QC / QA Coordinator Approval

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DART AEROSPACE

Container No: S133725
Part: D2743
Job No: 187068
Serial No/Batch: S133725
Revision:
Inspector:
Exp Date:
Instructions: Various STC's
Date: 12/02/18

Root Cause

Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐

P	☐					Positioned Wrong	☐
B	☐					Outside Dimensions	☐
C	☐					Over/Under tolerance	☐
C	☐					Part Incorrect	☐
Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐

OTHER : ☐